

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019242**Date Inspected:** 13-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

ZPMC SHIP # 18

This QA Inspector performed photo documentation along with Caltrans QA inspector (Mr.Reddy) on segment lift 11 (East) located on ZPMC ship # 18 prior to being shipped to San Francisco California for erection. The following locations and members documented are as followed:

Lift 11 West (Panel Point 103~108) following sequence pictures documented

Segment # 11 West

1. Intermediate Corner Assembly for cross and vertical truss post bolting area (Cross Beam and Counter Weight Side).
2. Longitudinal Diaphragm – Counter Weight side of segment.
3. Longitudinal Diaphragm – Crossbeam side of segment.

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4. Corner Assembly covering overall view, Deck Panel I-stiffeners, Edge Panel I-Stiffeners and Side Cross Beam and Counter Weight Side.
5. Sea fasteners installed at the Bottom Panel facing west and facing east Cross Beam and Counter Weight Side.
6. Floor Beam- Cross Beam and Counter Weight Side facing west and facing east.
7. Lower and Upper Chevron with sea fastening structures Cross Beam and Counter Weight Side facing west and facing east.

WELDING:

Segment 12BE

This QA Inspector observed ZPMC qualified welding personnel identified as 044515 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG3002A-001; located On Orthotropic Box Girder (OBG) Bottom Plate to Side Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-B-U2-FCM-1. See attached photo for further details.

Segment 12CE

This QA Inspector observed ZPMC qualified welding personnel identified as 040458 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG3002M-090; located On Orthotropic Box Girder (OBG) Bottom Plate to Longitudinal Diaphragm CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-2232-ESAB. See attached photo for further details.

Segment 12BE ~ 12CE

This QA Inspector observed ZPMC qualified welding personnel identified as 044504 perform Shielded Metal Arc Welding (SMAW), weld joint identified as LD3010-001-058; located On Orthotropic Box Girder (OBG) Side Plate T-rib Hold Back Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

Segment 12BE ~ 12CE

This QA Inspector observed ZPMC qualified welding personnel identified as 040458 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG3002M-090; located On Orthotropic Box Girder (OBG) Corner Assembly Edge Plate to Edge Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-2231-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer